

Ship Oct. 25

Work Order ID 62586 - 1



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Monday, October 04, 2010 3:21:46 PM

Item ID: D206-628-022BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step RH, Blue

SPLIT

Start Date: 10/5/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00

Customer:



Reference:

Approvals: Process Plan: mf

Date: 10-10-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-022 CHG 003

8 10/10/20

HJ for BG 10-10-19

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10/10/19 sf

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8 10/10/20

(XZ)
RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D206-628-022BL

Accept



Setup Start



Revision ID:

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Item Name: Heli-Access-Step RH, Blue

Start Date: 10/5/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00				10/10/28	28	2	SL
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-022 Location: <u>114</u> PPP Rev: <u>C</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/10/28

mf
10-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 62586

Parent Item: D206-628-022BL

Parent Item Name: Heli-Access-Step RH, Blue

Start Date: 10/5/2010


Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevF: add D2724-042 DD 09.11.17 verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A		Purchased	No				Each	168.0000	4	16			
													
Bolt													

Location	Loc Qty	Loc Code
----------	---------	----------

ST357	152	
-------	-----	--

114752	1	
--------	---	--

115371	150	
--------	-----	--

115422	1	
--------	---	--

ST358	16	
-------	----	--

113359	16	
--------	----	--

AN4-15A		Purchased	No				Each	577.0000	8	32			
													
Bolt													

Location	Loc Qty	Loc Code
----------	---------	----------

ST338	112	
-------	-----	--

ST358	465	
-------	-----	--

107737	12	
--------	----	--

108868	60	
--------	----	--

109148	4	
--------	---	--

111295	52	
--------	----	--

112905	12	
--------	----	--

114232	3	
--------	---	--

114292	32	
--------	----	--

114615	56	
--------	----	--

114784	58	
--------	----	--

115108	76	
--------	----	--

115371	100	
--------	-----	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 62586

Parent Item: D206-628-022BL

Parent Item Name: Heli-Access-Step RH, Blue

Start Date: 10/5/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

AN960JD416 NAS1149D0463J Purchased No

Each 24.0000 12 48



Washer



10/10/10 115647

Location

Loc Qty

Loc Code

ST300

24

113288

24

D2724-042 Manufactured No

Each 0.0000 1 4



206L Step Assembly



362588 10/10/10

D2731-7 Manufactured No

Each 55.0000 4 16



Mounting Lug



362590 10/10/10

Location

Loc Qty

Loc Code

ST420

16

60996

16

ST470

39

59202

15

61653

24

D2732-030 Manufactured No

Each 0.0000 8 32



Rubber Cushion



362589 10/10/10

D3394-043 Manufactured No

Each 31.0000 4 16



Lug Assembly



362589 10/10/10

Location

Loc Qty

Loc Code

ST420

19

60997

19

ST475

12

52331

12

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 62586



Parent Item: D206-628-022BL



Parent Item Name: Heli-Access-Step RH, Blue

Start Date: 10/5/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

Each

4,434.000

12

48



10/10/19 54 (40)

Nut

Location

Loc Qty

Loc Code

ST300

4434

113422

68

114523

8

114718

16

114784

32

115108

1310

115589

1900

115621

1100

48

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

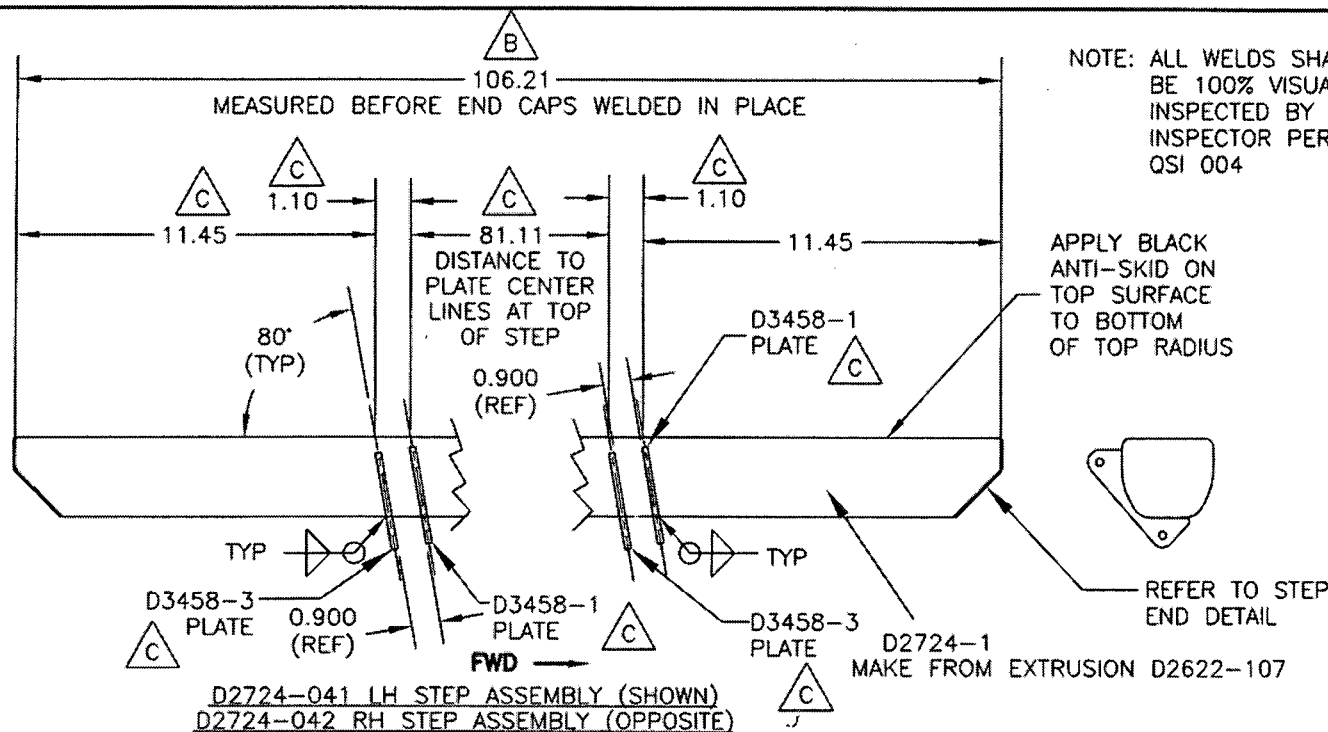
Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	AN960JD416	WASHER
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

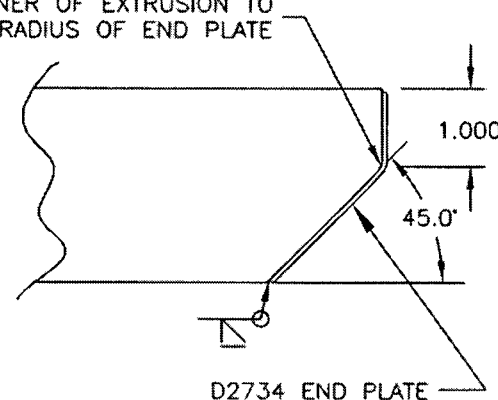
REFERENCE ONLY
DART

RELEASED
05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2724-041	LH STEP ASSEMBLY
		D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19	TITLE	D2724	REVISION
				05.09.19
				97.12.04
				98.10.19
				NEW ISSUE
				UPDATED WELD DETAIL
				REVISED TOLERANCES
				RE-DESIGN, ADD D3458-1/-3
				206L/407 STEP ASSEMBLY
				SCALE
				NTS
				SHEET 1 OF 1
				REV. C